

# Work Order ID 86249

**\*86249\***

Page 1

June-25-12 10:35:22 AM

Item ID: D3339-5

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Wearpad Fwd

Start Date: 25/06/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/25 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3339

Rev

Rev-B 12/06/26

(12)

MAT NOT pulled

100

0.00

**\*100\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3339 Dwg Rev: B Prog Rev: B 2-  
Deburr if necessary

1010 .063

B12-G-27

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Memo

0.00

Quality Control

B12-G-27

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

Quality Control

572662

(712)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D3339-5

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Setup Start **\*NS1\***

Revision ID:

Item Name: Wearpad Fwd

Stop **\*NS2\***

Start Date: 25/06/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00							
<b>*130*</b>									
Brake NC	Memo	0.00							
Brake NC	1-Deburr if necessary2-Form as per dwg D3339 using DT8326 and DT8261								
140	QC5- Inspect part completeness to step on W/O	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									
150	Large Fab	0.00							
<b>*150*</b>									
Large Fab	Memo	0.00							
Large Fab	Weld hard coat 7560 as per dwg D3339, using DT8210 & DT8810 layout jig								

SB  
12/6/03

5/12/03

12

12

ME

12-07-23

m 12/603 → 228

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Work Order ID 86249

**\*86249\***

Page 3

June-25-12 10:35:22 AM

Item ID: D3339-5

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Wearpad Fwd

Stop

**\*NS2\***

Start Date: 25/06/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 10/07/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

**\*160\***

QC

Memo

0.00

Quality Control



170

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

**\*170\***

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

W121279

3200F

12:20

12X

MZ 12/17/24

180

QC3- Inspect Part Finish

0.00

**\*180\***

QC

Memo

0.00

Quality Control

12

12/17/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**\*86249\***

Page 4

**Accept**

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

**Cust Item ID:**

**\*6\***

\*6\*

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

190

\*190\*

## Packaging

0.00

### Packaging

## Memo

0.00

## Packaging

200

QC21- Final Inspection - Work Order Release

0.00

**\*200\***

QC

## Memo

0.00

## Quality Control

MLJ 12/07/25

MS 12/07/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

June-25-12 10:35:28 AM

Page 1

Work Order ID: 86249

\*86249\*

Parent Item: D3339-5

\*D3339-5\*

Parent Item Name: Wearpad Fwd

Start Date: 25/06/2012

Required Date: 10/07/2012

Start Qty: 6.00

Required Qty: 6.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
			No										
											(12)	1.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

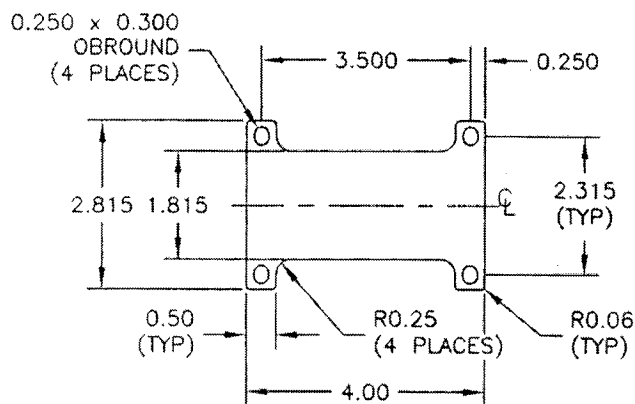
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



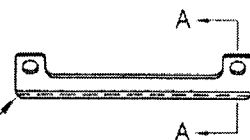
RELEASED  
05-11-27

DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3339	REV. 8 SHEET 1 OF 3
DATE 05.11.22		TITLE REPLACEMENT WEARPAD	SCALE 1:3
A	05.06.06	NEW ISSUE	
B	05.11.22	CORRECTED HOLE SPACING D3339-7F	

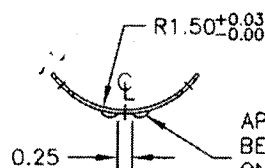


**D3339-1F FLAT PATTERN**

APPLY 7560  
HARDCOAT WELD BEADS  
PER DT3339-3T1  
AFTER FORMING  
(SEE SECTION A-A)



**D3339-3 CENTER WEARPAD**  
(MADE FROM D3339-1F)

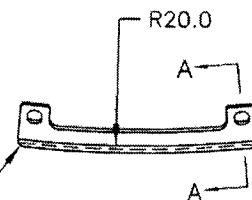


APPLY 7560 HARDCOAT WELD  
BEADS, 0.063 TO 0.125 THICK,  
ON BOTTOM SURFACE  
AFTER FORMING

**SECTION A-A**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 26249 MJS  
12/06/25

APPLY 7560  
HARDCOAT WELD BEADS  
PER DT3339-5T1  
AFTER FORMING  
(SEE SECTION A-A)



**D3339-5 FORWARD WEARPAD**  
(MADE FROM D3339-1F)

**D3339-1F/-3/-5 WEARPAD**

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 16 GAUGE (0.060 THICK)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP CORNERS 0.063 MAX

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

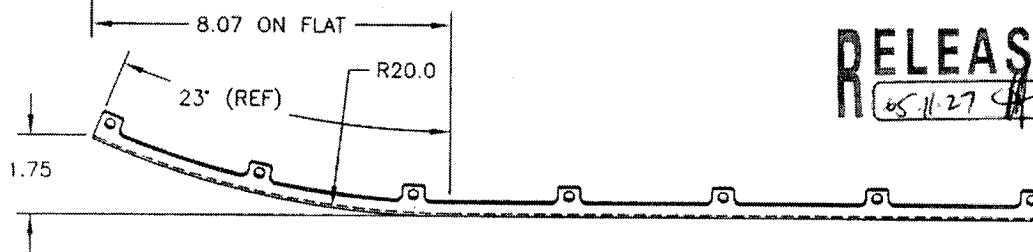
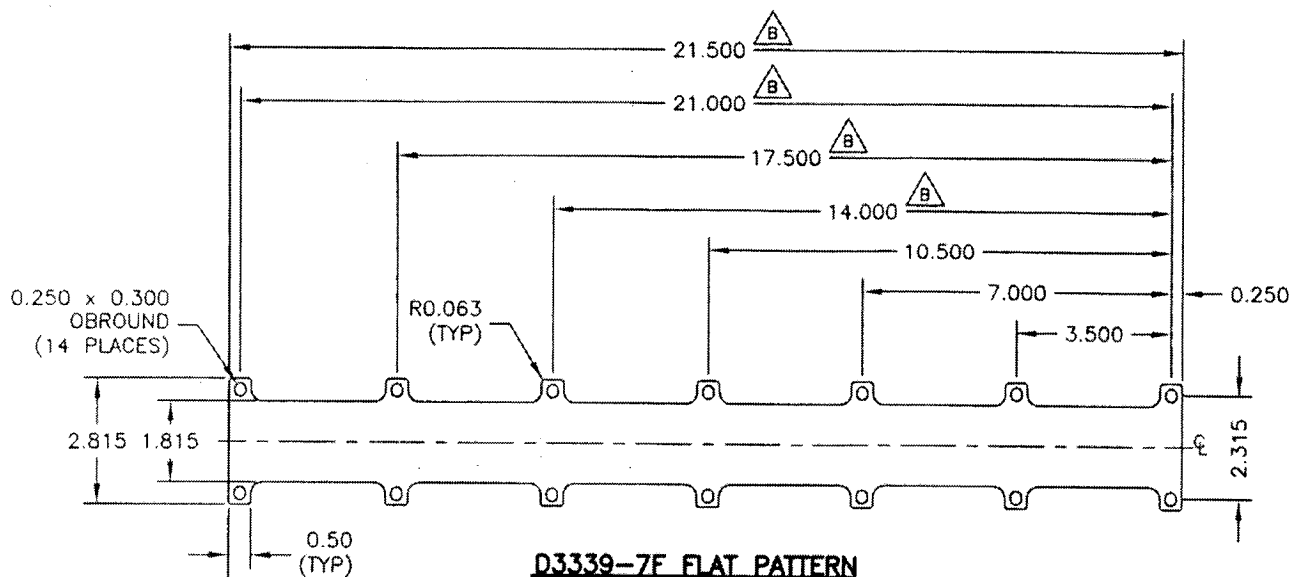
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3339	REV. B SHEET 2 OF 3
DATE 05.11.22		TITLE REPLACEMENT WEARPAD	SCALE 1:4



RELEASED  
05.11.27

APPLY 7560 HARDCOAT  
WELD BEADS PER DT3339-7T1  
AFTER FORMING  
(SEE SECTION A-A)

**D3339-7 LONG FORWARD WEARPAD**

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR  
CSA G40-21, 38W/44W/50W/60W/70W SERIES  
COLD ROLLED STEEL 16 GAUGE (0.060 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP CORNERS 0.063 MAX

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6202

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

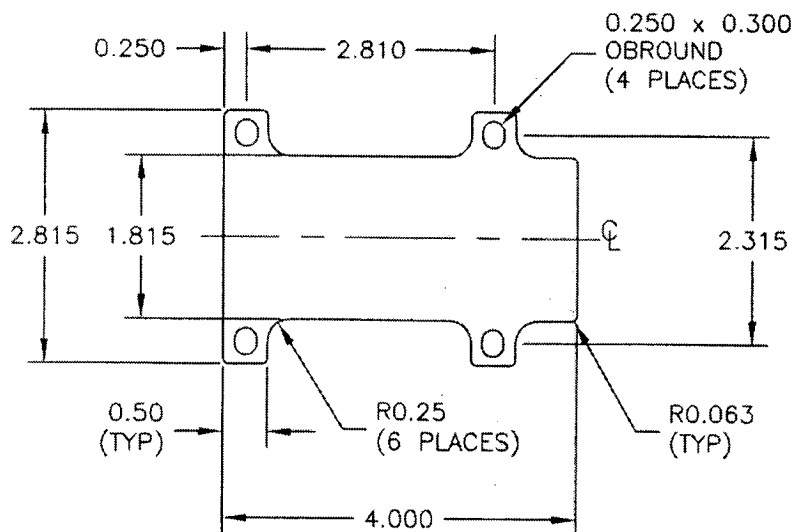
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



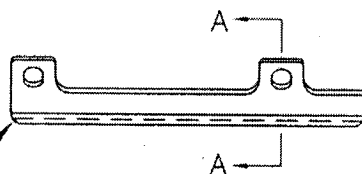
DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3339	REV. B SHEET 3 OF 3
DATE 05.11.22		TITLE REPLACEMENT WEARPAD	SCALE 1:2



**D3339-9F FLAT PATTERN**

**RELEASED**  
05.11.27 H

APPLY 7560  
HARDCOAT WELD BEADS  
PER DT3339-9T1  
AFTER FORMING  
(SEE SECTION A-A)



**D3339-9 AFT WEARPAD**

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 16 GAUGE (0.060 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP CORNERS 0.063 MAX

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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W/O:		WORK ORDER CHANGES					
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